

Defect Details

NC No.	8000808350
NC Date	18/10/2022
NC Submission Date	
Part No.	013AQ00123
Part Name	BASE VALVE CASE GROOVED
Supplier Name & Code	100177-SPECIALITY SINTERED PRODUCTS P
ETL Plant	1116-ETL K-120 Suspension
Defect Details	NOT AS PER SPECIFICATION-OPRATION MISSING

1. Problem Description

Defect Description	Groove operation missing concern repetitively observed.
Detection Stage	Inprocess
Problem Severity	Fitment
NG Quantity	8
Is Defect Repeatative?	Yes
Defect Sketch / Photo	

Supplier Communication Details

Quality Head Email ID	ganeshpadwalkar@specialitysintered.com
Plant Head/CEO Email ID	sandeep.gaikwad@ssplpune.com
MD Email ID	lalit.chaudhari@ssplpune.com

2. Stock Details & action taken for NG parts

Location	ETL End	Warehouse	Transit	Supplier FG	Supplier WIP	Total
Total Qty	20000	30000	0	15000	12000	77000
Check Qty	19994	30000	0	15000	12000	76994
NG Qty	6	0	0	0	0	6

Action taken on NG part

Scrap	6
Rework	0
Under Deviation	0

Containment Action

SSPL representative visited to ETL for ICA at ETL End and Warehouse

3. Process Flow

Process Flow Description

Raw material inspection & Mixing - Forming - Sintering - Debarring - Steam - machining - Final Inspection - Oiling - Packagining - Dispatch

4. Process Details

Process / Operation	Machining
Outsource	Yes
Machine / Cell	Traun No 10
Machine / Cell No.	Traub section

5. Problem Analysis

Type	Possible Cause	Fact Verification	Jud
Man	Unskill Operator	Level 4 Operator At Machine .	X
Method	Input & Material Handling Not Ok	Verified No seprate Provision Provided To Unlodade Output Material.	O
Tool	Wrong Tool Used	Tool Verified Found Ok	X
Material	Wrong Raw Material	Material Checked As Per TC Found Ok	X
Machine	Machine Not Working Properly	Verified Found Ok	X

6. Inspection Method Analysis (Current)

Inspection Method	Other
Other Inspection Method	Visual
Check Point at Final Inspection	Yes
Checking Freq.	Sampling
Sampling	No
Sample Size	As Per Sam

7. Root Cause Analysis (Occurance)

Why 1	Without Machining Part Found At Customer End ..
Why 2	During Machining process Machine Input Material Mixed With Output Material. .
Why 3	No seprate Provision Provided To Unlodade Output Material.
Why 4	No Poke Yoka .
Why 5	
Root Cause (Occurance)	No Poke Yoka .

Root Cause Analysis (Outflow)

Why 1	Without Machining Part Found At Customer End .
Why 2	Defective part Pass from Final Inspection .
Why 3	Rejected parts Mixed With Ok Parts .
Why 4	Lock And Key Rejection Bin Not Available At Final Inspection Table .
Why 5	
Root Cause (Outflow)	Lock And Key Rejection Bin Not Available At Final Inspection Table .

8. Countermeasure (Occurrence , Outflow & System side Actions)

Type	Countermeasure Details	Responsibility	Target Date	Actual Date	Status
Outflow	Lock And Key For Rejection Material Provision Given To Inspection Table .	MR Sunil	20/10/2022	21/10/2022	Completed
Occurance	Seperate Provision Provided To Unloaded Output material .	Mr Mahesh Narkhede	25/10/2022	27/10/2022	Completed

9. Inspection Method After Customer Complaint

Change In Inspection System	Yes
Change Details	Lock And Key For Rejection Material Provision Given To Inspection Table .
Inspection Method	Other
Other Inspection Method	Visual Inspection
Check Point at Final Inspection	Yes
Checking Freq.	100%
Sampling	No
Sample Size	100%

10. Evidence of Countermeasure

Occurance (Before)	No Separate Provision Provided To Unloaded Output material . 291_Occurance_Before.xlsx
Occurance (After)	Separate Provision Provided To Unloaded Output material . 291_Occurance_After.xlsx
Outflow (Before)	Lock And Key Provision Not Available For Rejected Material At Inspection Table 291_Outflow_Before.xlsx
Outflow (After)	Lock And Key Provision Given For Rejected Material At Inspection Table . 291_Outflow_After.xlsx

11. Horizontal Deployment

Horizontal Deployment Required	Yes
Applicable Machine / Model / Plant	-

12. Document Review

Documents	InspCheckSheet
Specify Other Document	Quality Alert .

13. Effectiveness Of Action

Reviewed Quantity	1200
Reason for submission	Completed.

